

Date: Thursday, 10/04/2008 11:53:22 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-667-203A
Job Number	: 38521		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D206667203A <i>W</i>
This Issue	: 10/04/2008 S.O. No. :	Drawing Number	: REWORK-ARM.SHIELD
Prsht Rev.	: NC	Project Number	:
First Issue	: // Type : CROSSTUBES	Drawing Revision	:
Previous Run	: 38508	Material	:
Written By	: <i>W</i>	Due Date	: 17/04/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	CROSSTUBES	CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

RTN FROM OFFSHORE INVENTORY

1 X D206-667-203A B 33934 *CHG 001*
PC 8/1/7

2.0	D206667203A	Crosstube Installation W/ armour shield
-----	-------------	---



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Installation W/ armour shield
 B/N 33934

3.0	SPRAY PAINTING	SPRAY PAINTING
-----	----------------	----------------



Comment: REMOVE SUPPORTS, CLAMPS AND HARWARE

DISCARD HARDWARE IF NO GOOD

KEEP CLAMPS AND SUPPORTS TO REASSEMBLE

STRIP TUBE COMPLETELY TO REMOVE ARMOR SHIELD

m
08 04 22 *(1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/04/2008 11:53:22 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-203A

Job Number: 38521

Part Number: D206667203A

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/23 (41)

5.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 08 04 24 (1)

6.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 08-04-25

7.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

u/a not already installed

8.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

RE-ASSEMBLE

INDICATE ANY NEW PARTS USED:

D2856-400-773
Abrasion strip: B35900

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

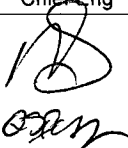
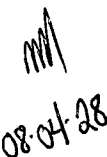
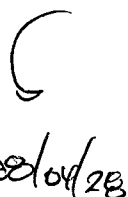
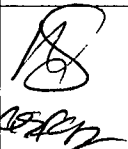
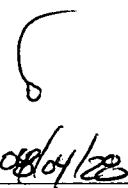
2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

ml 08 04 28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-203 PAR #: N/A Fault Category: Prod / x-tubes NCR: Yes No DQA: D Date: 08/05/01
 QA: N/C Closed: D Date: 08/05/01

NCR: 38521		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/28	8.0	Abrasion strip was torn underneath support.		Disassemble one side, & replace torn abrasion strip. Re install existing hand war D206-667-203 B: 35900	 08-04-28	 08/04/28		 08/04/28

NOTE: Date & initial all entries

Date: Thursday, 10/04/2008 11:53:23 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-203A

Job Number: 38521

Part Number: D206667203A

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/28 (HL)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ENSURE ORIGINAL KIT IN BOX

Identify and pack for shipping as per PPP D206-667-203 CHG 001

Location:

PPP Rev:

Rev #3

18 08/04/29 (AL)

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/04/29 (HL)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/30 (AL)

Job Completion



MF 08-04-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 - #**UNDER REVIEW**
06.08.10 RH
re draw detail F

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

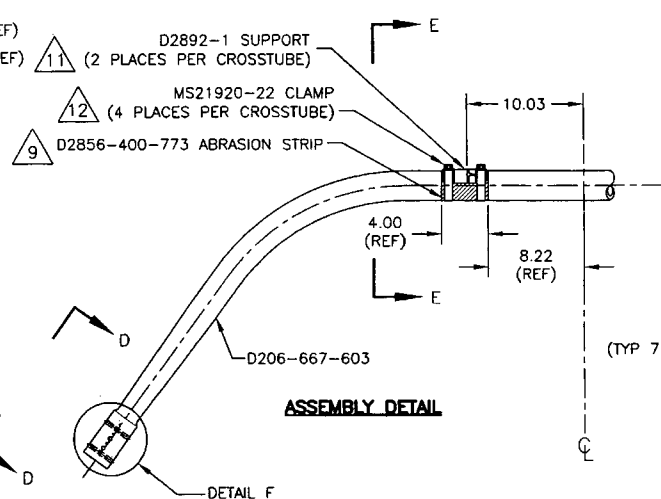
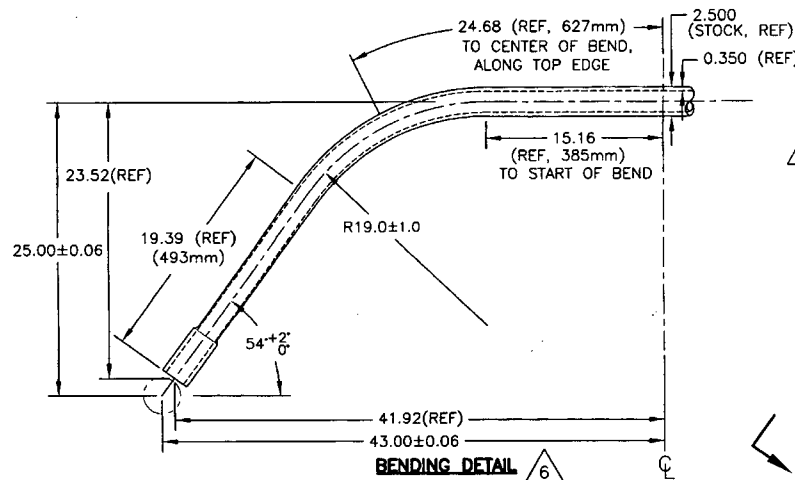
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

V/B 38521

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

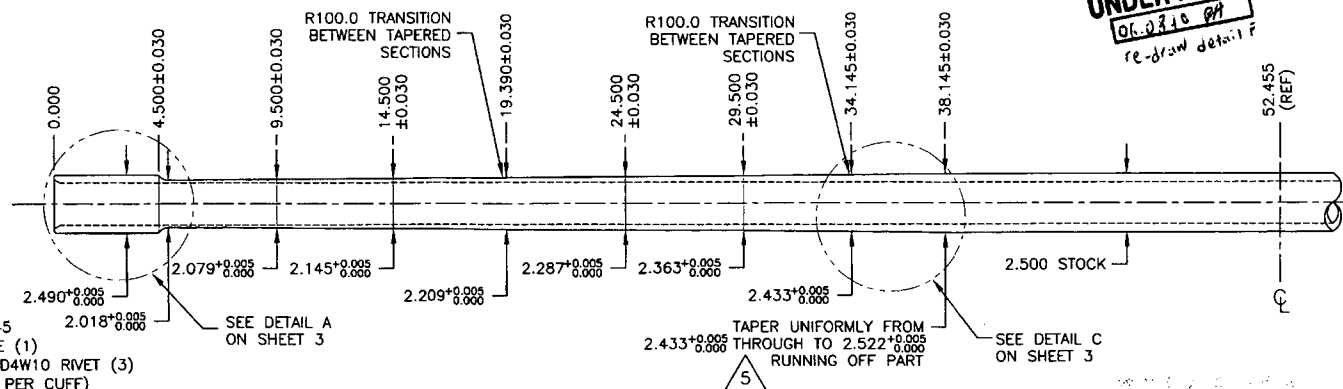
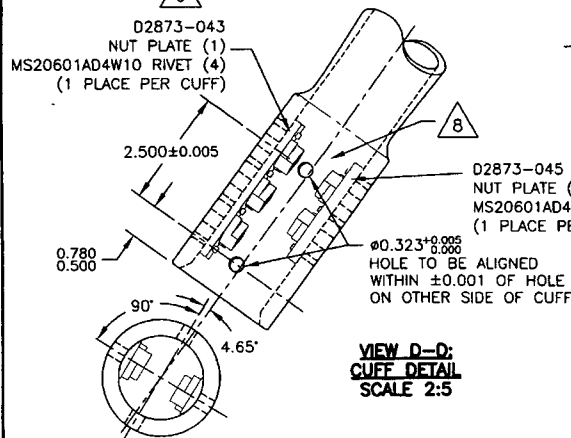
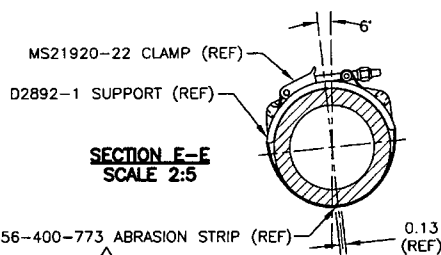


△ B $\phi 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HOLE ON OTHER SIDE OF CUFF

PILOT $\phi 0.128$
C'SINK $\phi 0.225 \times 100'$
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

DETAIL F
SCALE 2:5



UNDER REVIEW
06.07.10 PH
re-draw detail F

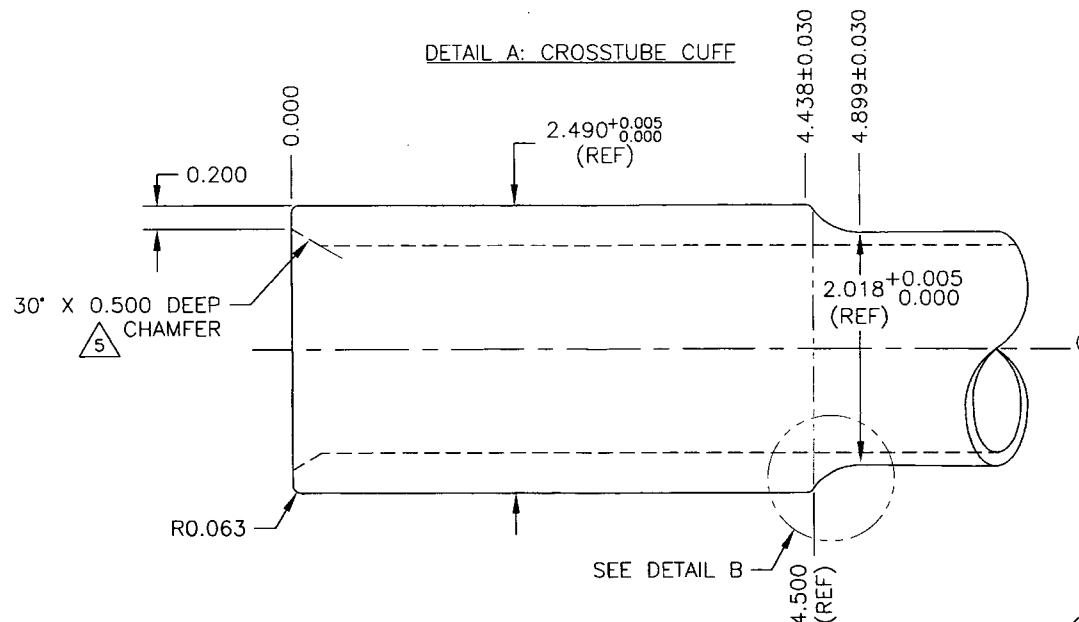
05.07.26 #

COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

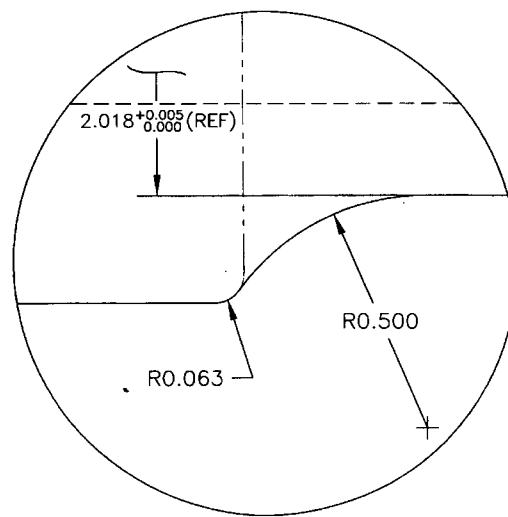
DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:10

DETAIL A: CROSSTUBE CUFF



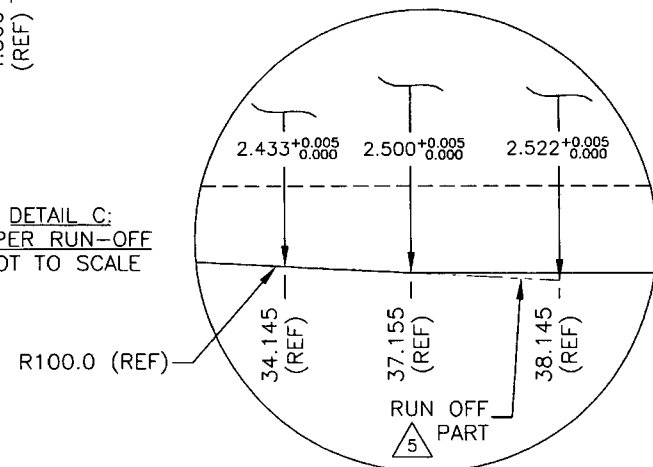
05.07.26 PH

UNDER REVIEW
06.03.10 PH
re-drawn detail F



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C: TAPER RUN-OFF NOT TO SCALE



COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN
PH

DRAWN BY
PH

DART

DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

CHECKED

PH

APPROVED

PH

DRAWING NO.

D206-667-243

REV. 8

SHEET 3 OF 3

DATE

05.07.26

TITLE

CROSSTUBE ASS'Y (206L HIGH AFT)

SCALE

1:1

DART Aerospace Ltd

CUSTOMER RETURN

08-001 (INT)
#R _____

Initiator: S. Williams **Date:** _____
Company: Off Shore (EG.) Location **Invoice #** _____
Phone No. _____ **Order Entry #** _____
Reason for return: Give to Linda to put back in Dart Inventory **Attach Copy of DHS Return Authorization #** N/A

Receiving: 4/17 **Freight Company:** Yellow **Prepaid** _____ **Collect** _____
Date Received: 4/17

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	DD06-667-103A	33933	Cross tube		
2	DD06-667-203A	33934			

Condition of packaging: GOO **Photograph required:** yes no
Paperwork attached: P/S NO **Invoice** _____ **ARC** _____ **Docs** _____ **Other** _____

QC:
Quarantine: _____ **Location:** _____ **Condition of Part:** _____
Inspect: _____ **Initial:** _____

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	

QA Coordinator:
Advise GM as to findings: _____ **Initial:** _____ **Date:** _____
Comments:
Attached copy to custom w/o

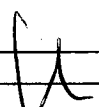

Issue credit: yes _____ no _____ GM Approval: _____ Date: _____	Invoice Amount: _____ Less Replacement: _____ Restock Fee: _____ Freight: _____ Net Credit: _____ DHS <input type="checkbox"/> Customer <input type="checkbox"/>
---	--

QA: Enter into Q-Pulse with reason for return & File original. **Signed:** _____ **Date:** _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit

Date: Thursday, 10/04/2008 11:53:22 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-667-203A
Job Number	: 38521		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D206667203A
This Issue	: 10/04/2008 S.O. No. :	Drawing Number	: REWORK-ARM.SHIELD
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : CROSSTUBES	Drawing Revision	:
Previous Run	: 38508	Material	:
Written By	: 	Due Date	: 17/04/2008 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

CROSSTUBES

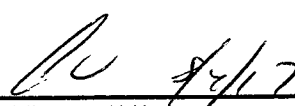
CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

RTN FROM OFFSHORE INVENTORY

1 X D206-667-203A B 33934



2.0

D206667203A

Crosstube Installation W/ armour shield



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Crosstube Installation W/ armour shield

B/N 33934

3.0

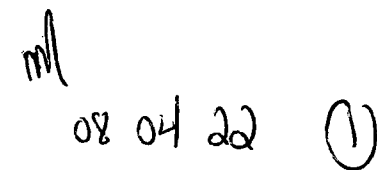
SPRAY PAINTING

SPRAY PAINTING



Comment: REMOVE SUPPORTS, CLAMPS AND HARWARE

DISCARD HARDWARE IF NO GOOD

KEEP CLAMPS AND SUPPORTS TO
REASSEMBLESTRIP TUBE COMPLETELY TO
REMOVE ARMOR SHIELD


Red label -
 White + PPW

DP 08.4.28